

Date: Wednesday, 03/09/2008 10:29:33 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 41739		
Estimate Number	: 11039		
P.O. Number	:	Part Number	: D28041
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: D2804 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 41080	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 08.9.03</u>		
Comment	: Est. A00.11.06 New Issue EC		
	: Est. B06.05.30 Blanks on wtjetEC		
	: Est Rev:C As per Rev C 06-11-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00
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Comment: Qty.: 0.7875 f(s)/Unit Total: 4.7250 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 109253 IB 8-9-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: C

Prog Rev: C

IB 8-9-19

6

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

J.L 08/10/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/10/10

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 08/10/10 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:33 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 41739

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 08/10/10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M. 08/10/10

(6x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 57151A

AS 08/10/10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/14

Job Completion



CMF 08-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41739
Description: Bracket		Part Number: D2804-1
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

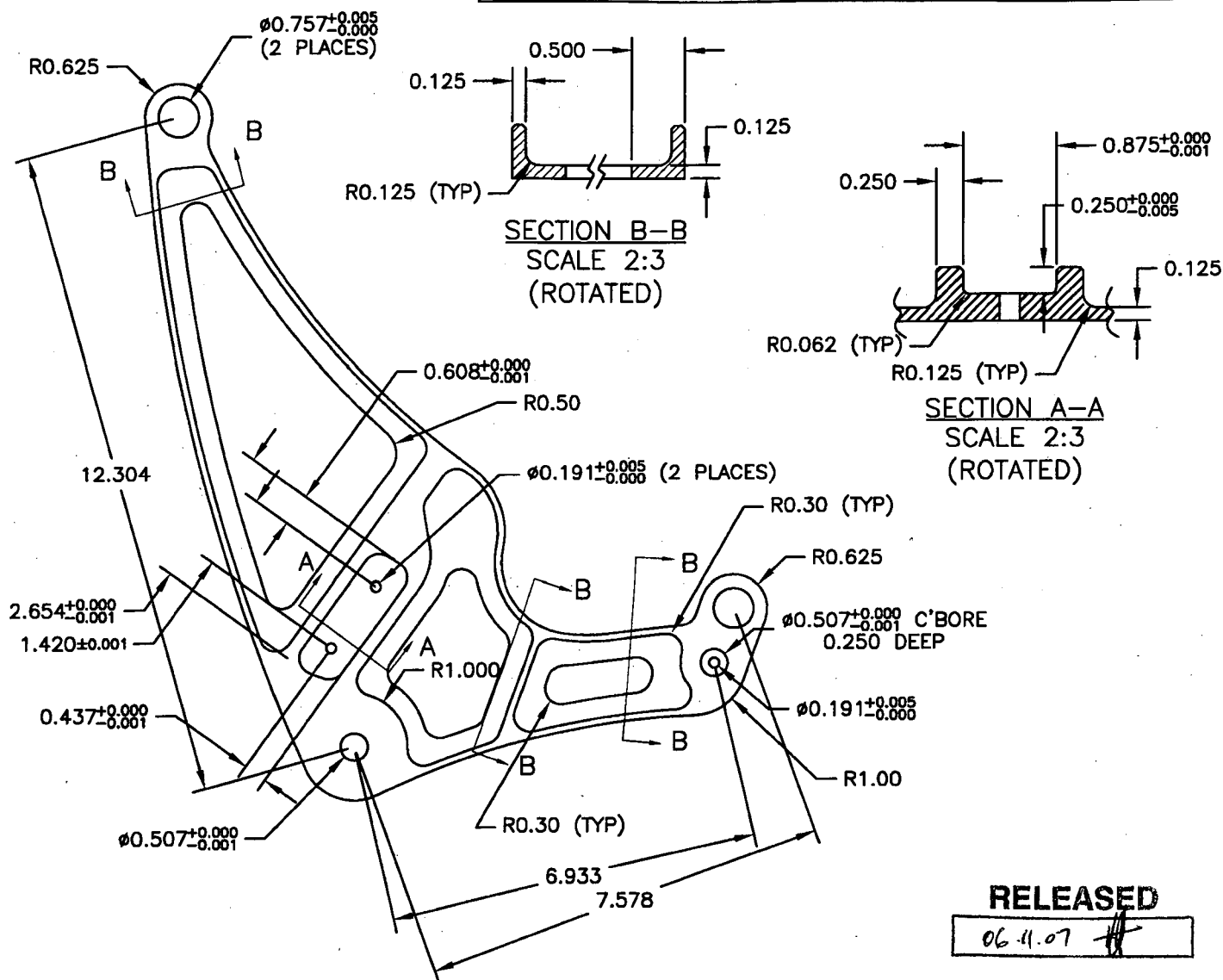
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.010/-0.001	.7573	✓			
Ø0.191	+0.005/-0.001	.191	✓			
1.420	+/-0.001	1.420	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
0.250 deep	+/-0.010	.256	✓			
Ø0.507	+0.000/-0.001	.5061	✓			
Ø0.191	+0.005/-0.000	.191	✓			
6.933	+/-0.010	6.932	✓			
7.578	+/-0.010	7.578	✓			
12.304	+/-0.010	12.304	✓			
0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.499	✓			
0.125	+/-0.010	.135	✓			
0.250	+/-0.010	.250	✓			
0.875	+0.000/-0.001	.875	✓			
0.250	+0.000/-0.005	.249	✓			

Measured by: JL	Audited by: JS	Prototype Approval:	N/A
Date: 08/10/09	Date: 08/10/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	JS



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2804
				REV. C
				SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

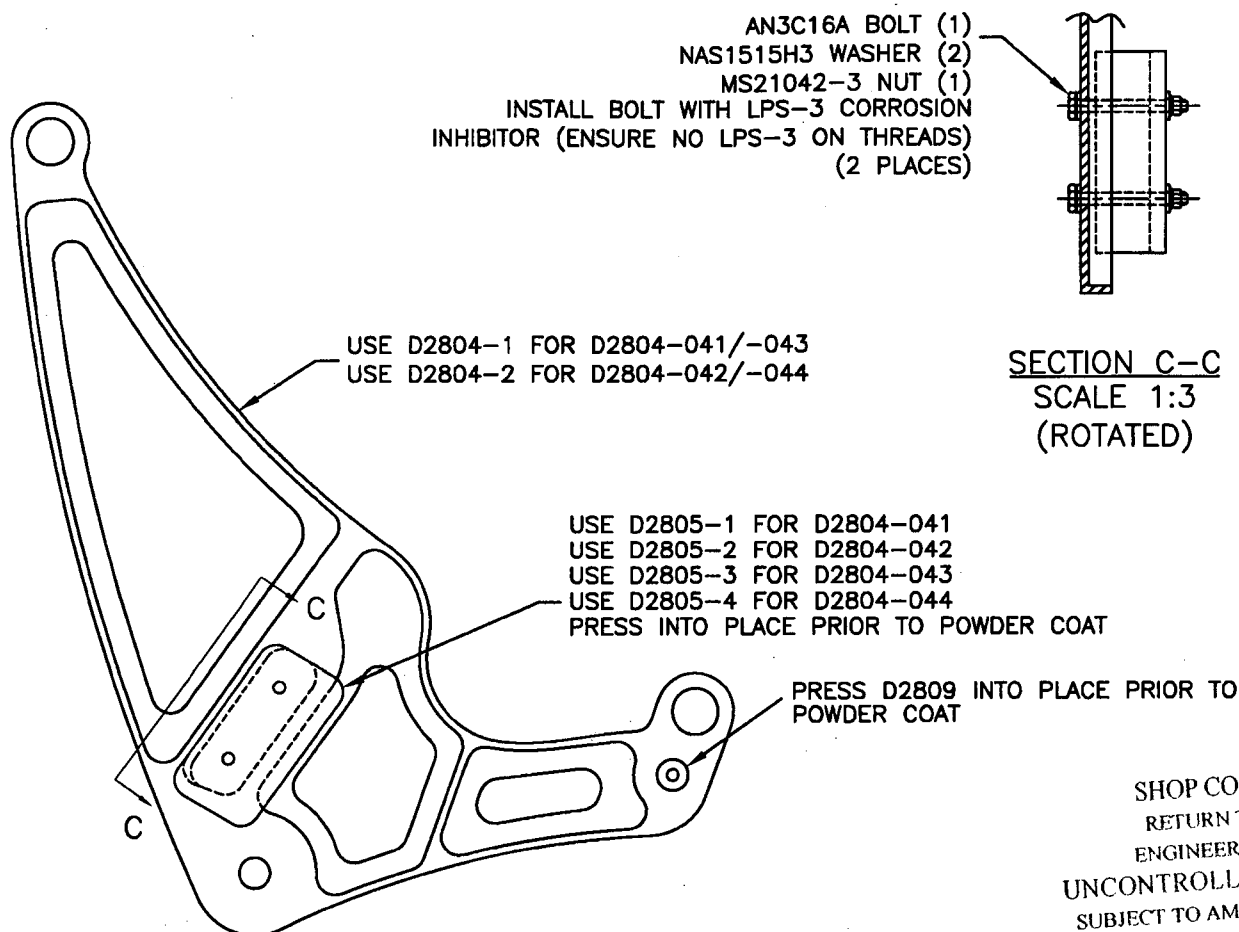
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3



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WORK ORDER

NO. 41739
RELEASED

06.11.07 H

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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